

Replacement

1. Remove the related parts.

- Windshield
- Rear window
- Sunvisor
- Ceiling lights
- Headliner
- Moonroof frame (for some models)

2. Pull out and straighten the damaged area to approximately the original shape.

NOTE: Check the inner front pillar and the inner center pillar for position and damage.

Cut the roof panel and pull out the pillars if necessary.

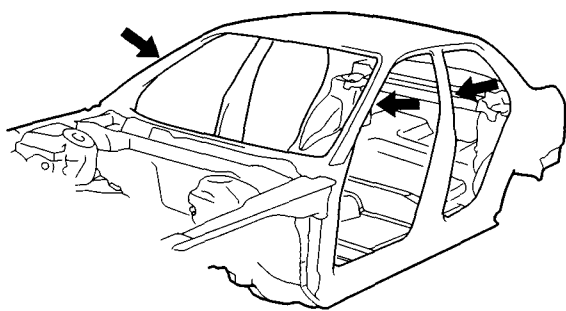
- Pull out the damaged area with the frame straightener before removing the roof panel.
- Attach the vehicle to the frame straightener by tightening the underbody clamps located at the horizontal pinch welds.

3. Keep the body level.

NOTE: Refer to the Accord Service Manual for safety stand location points.

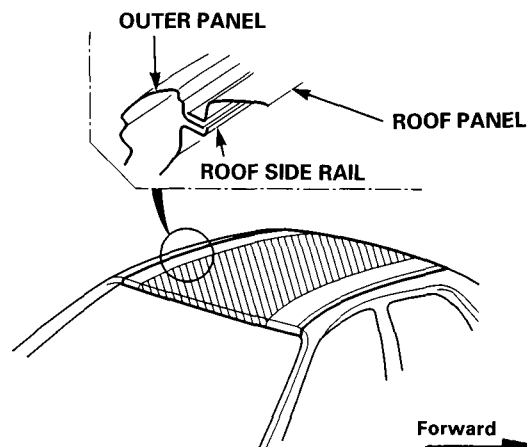
Jack-up the body at the front and back. Place safety stands to support engine weight, at the four designated places of the side sills.

NOTE: Make sure that the right and left pillars are parallel with the windshield surface. Check the door for proper opening and closing.

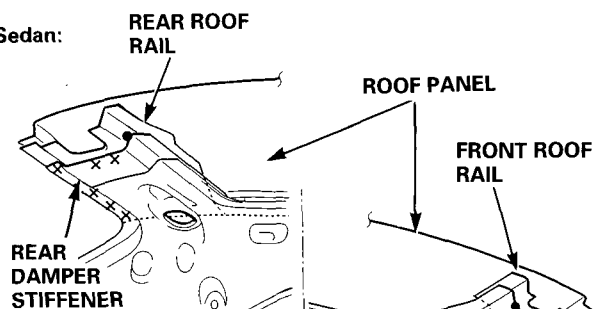


4. Cut off the shaded areas of the roof panel.

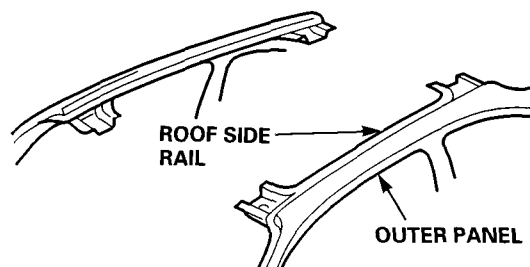
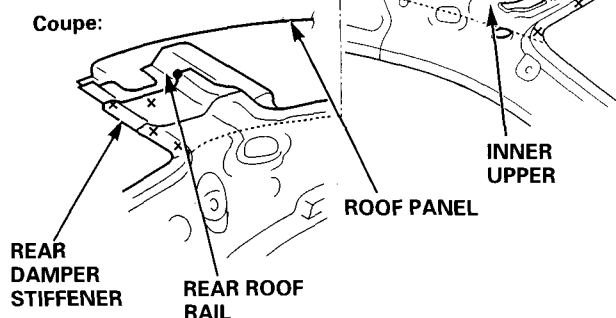
- Cut the roof rail weld flange with a handsaw at the four corners.
- Using a chisel, pry off the roof panel along the bold lines as shown.
- Center punch around the spot weld imprints of the roof gutter welded flange.
- Drill holes using the spot cutter.
- Using a chisel, pry off the welded flange.



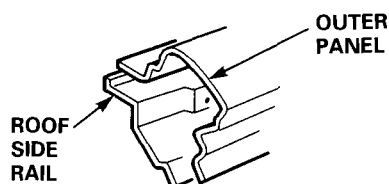
Sedan:



Coupe:



NOTE: If necessary, replace the outer panel (see pages 4-33, 4-34).



(cont'd)

Roof Panel

Replacement (cont'd)

5. Plug weld the holes with a MIG welder.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves, and safety hoses.

- Level and finish the burrs on the welded flanges with a disc sander.

⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- Even out the roof side rail welded flange with a hammer and dolly for a close fit with the roof panel welded flange.

6. Apply paint to the underside of the new roof panel.
See Paint Repair section.

- ⚠ WARNING**
- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
 - Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.
 - Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.

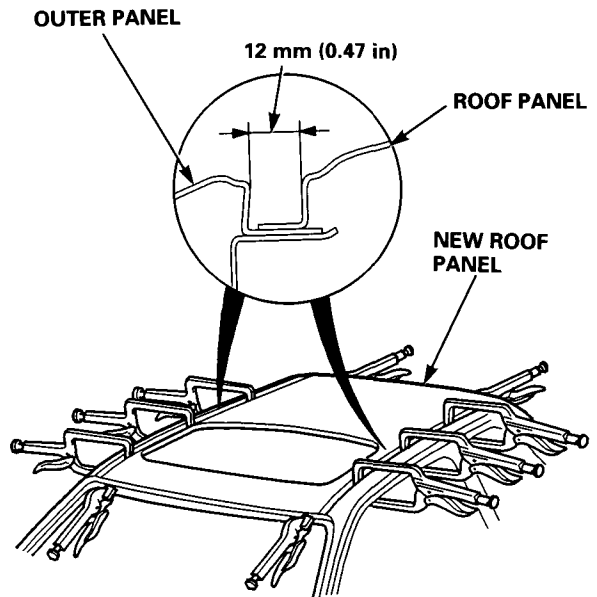
7. Set the new roof panel.
- Sand off the undercoat from both sides of the flange sections to be spot welded to expose the steel plate.

⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.

- Clamp the roof panel with vice-grips.

NOTE:

- Check that the flange surfaces fit closely. Be careful not to twist or deform the roof panel.
- Check the width of the groove of the roof moldings on both sides.
- Apply the spot sealer to the welding surface when spot welding.



- Check the body dimension (see [section 6](#)).

8. Tack weld the new roof panel.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves, and safety hoses.

- Spot weld the clamped sections to temporarily install the roof panel.
- Set the windshield and rear window, and check the roof panel for proper installation.
- Install the roof molding and check the width of the groove.

9. Perform the main welding.

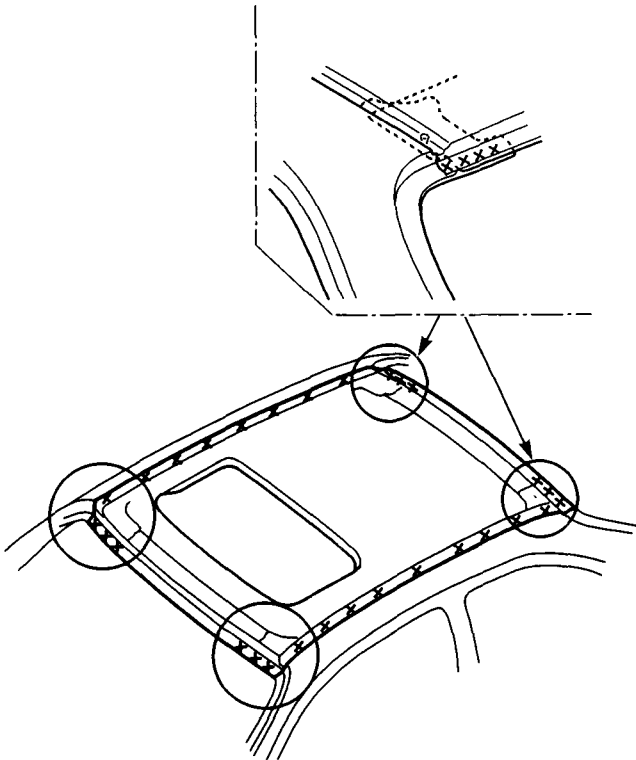
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Spot weld the roof rails at the front and rear.
- Spot weld the roof arch.
- Make 20% to 30% more spot welds than there were holes drilled.

NOTE: If there isn't room for spot welds, compensate by MIG welds.

- Smooth the spot weld areas under the windshield and rear window with a hammer and dolly.

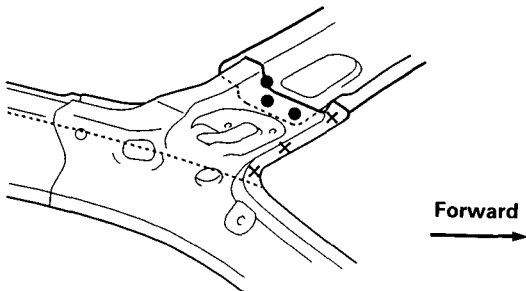
NOTE: After welding the pillars, grind and finish the welded areas flat and blend them into the roof panel.



- Weld the roof rail from the inside by MIG welding as shown.

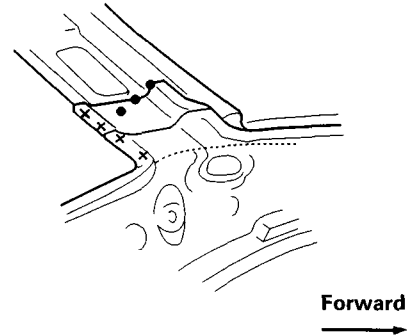
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

⟨Front⟩

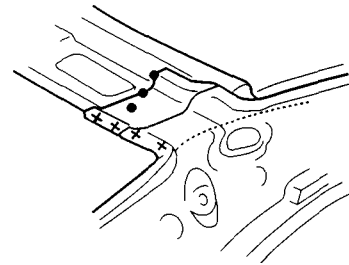


⟨Rear⟩

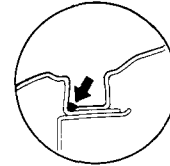
Sedan:



Coupe:



10. Apply and level the sealer to the welded areas.



11. Apply the paint See Paint Repair section.

⚠ WARNING

- **Ventilate** when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
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- **Paint is flammable.** Store it in a safe place, and keep it away from sparks, flames, or cigarettes.

12. Apply an anti-rust agent to the inside of the roof side rail.

13. Install the related parts in the reverse order of removal.

14. Check and clean.

- Check the windshield and rear window for water leaks.
- Make sure the moonroof operates smoothly.
- Clean the passenger compartment thoroughly.